

Work Order ID 66254

February 8, 2011 10:07:01 AM



Page 1

Item ID: D3650-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Tunnel Top Panel Assembly

Start Date: 2/08/11 Start Qty: 100



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/02/08

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3650

Rev C

100

Pick Kit

0.00

SB 11/03/28



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00

SB 11/03/28



Small Fab

Memo

0.00

Small Fab

1-Assemble as per dwg D3650 2- Seal all mating surfaces and all gaps using
Proseal 700 fire wall sealant as per dwg D3650 Batch: M116669

120

QC5- Inspect part completeness to step on W/O

0.00

SB 11/03/28



QC

Memo

0.00

Quality Control

(x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66254

February 8, 2011 10:07:01 AM



Page 2

Item ID: D3650-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Tunnel Top Panel Assembly

Start Date: 2/08/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> <u>w/o 65406</u> Memo	0.00 0.00		SB 11/03/28		(2)			
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

OK 11/03/29
MF 11-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





February 8, 2011 10:07:00 AM

Parent Item Name: Tunnel Top Panel Assembly

Required Date: 2/22/11

Required Qty: 1.00

Comments:	IPP Rev:A	New Issue	07-11-12	EC	verified by: DD
	IPP Rev:B	Ecn 1113P	08-01-22	DD	verified by:EC
	IPP Rev:C	Ecn1162	08-04-02	DD	verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C10	NAS1149C0363 R	Purchased	No			100	Each	0.0000	8	8			
													
WASHER													
AN3C3A		Purchased	No			110	Each	333.0000	8	8			
													
Bolt													
					<u>Location</u>								
					ST350			<u>Loc Qty</u>		<u>Loc Code</u>			
								333		B117141		16	
					115159			40					
					116081			104					
					116590			89					
					116704			100					
D3650-1		Manufactured	No			110	Each	1.0000	1	1			
													
Aft Panel													
					<u>Location</u>								
					ST189			<u>Loc Qty</u>		<u>Loc Code</u>			
								1		65542			
					61743			1				1	
D3650-3		Manufactured	No			110	Each	3.0000	1	1			
													
Center Panel													
					<u>Location</u>								
					ST189			<u>Loc Qty</u>		<u>Loc Code</u>			
								3					
					53842			3					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 8, 2011 10:07:00 AM

Page 2

Work Order ID: 66254



Parent Item: D3650-041



Parent Item Name: Tunnel Top Panel Assembly

Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 1.00

Required Qty: 1.00

D3650-5

Manufactured No

110

Each

2.0000

1

1



28 11/03/28

Fwd Panel

Location

Loc Qty

Loc Code

ST189

2

61744

2

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

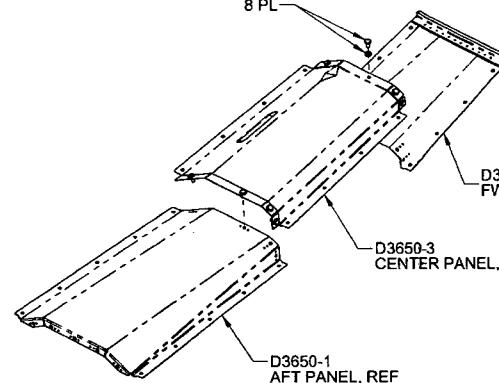
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER

AN3C-3A BOLT
AN960C10 WASHER
8 PL



D3650-5
FWD PANEL, REF

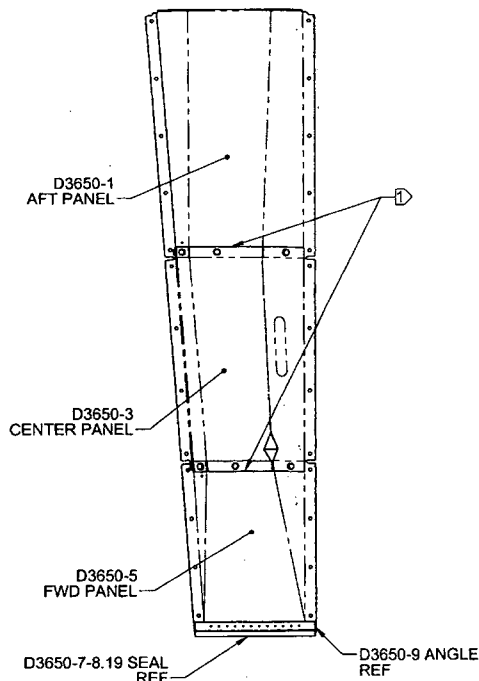
D3650-3
CENTER PANEL, REF

D3650-1
AFT PANEL, REF

DEO ATTACHED

UNDER REVIEW
OK
07.02.08
PAR 07.008
07.06.21

RELEASED
07.11.17



D3650-1
AFT PANEL

D3650-3
CENTER PANEL

D3650-5
FWD PANEL

D3650-7-8.19 SEAL
REF

D3650-9 ANGLE
REF

D3650-041 TUNNEL TOP PANEL ASSEMBLY

NOTES:

- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

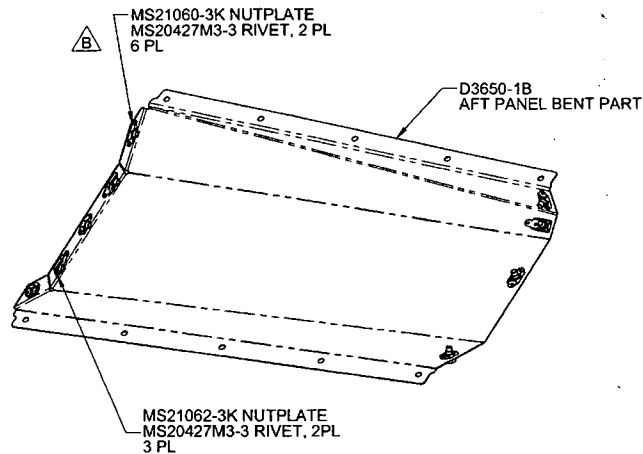
NO. 66254

CL1102108

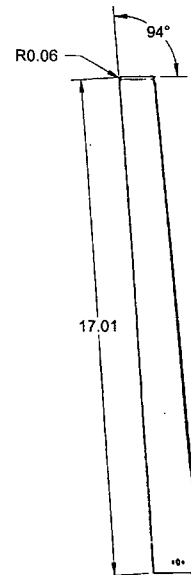
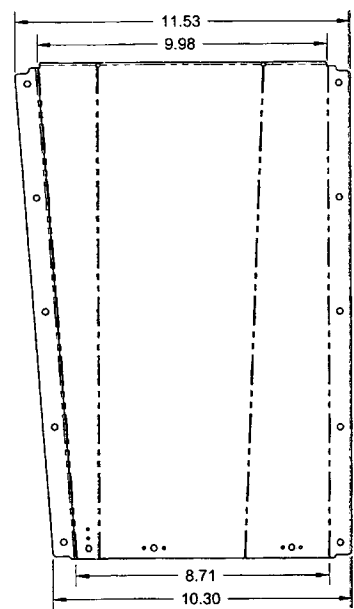
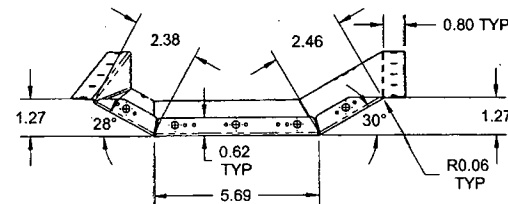
C	REFORMATTED TO NEW STANDARDS; RELOCATED PART LIST (ZN D2-2); ADDED SECTION VIEW J-J & REVISE DIMENSIONS (ZN B7-5, C4-5); ADDED RECESS LOCATION & REVISED DIMENSIONS (ZN C8-6, D5-6); MS20615-4M5 WAS CR3523-4-03 & NAS1149CN432R WAS AN960C4 (ZN D5-7; B5-7; B8-7)	RF	08.10.14
B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11/-11F TO SHEET 9; ADDED DETAIL I SHEET 9: RELOCATED D3650-11/-11F FROM SHEET 6; UPDATED DIMS O: D3650-11/-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	5	DRAWING NO.	REV. C
MFG. APPR.	NO	D3650	SHEET 1 OF 9
APPROVED	NO	TITLE	SCALE
DE APPR.	NO	TOP PANEL ASSEMBLY	
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

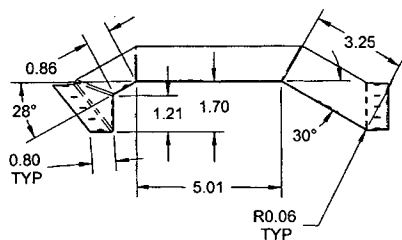
QTY -1	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21080-3K	NUTPLATE
3	MS21062-3K	NUT PLATE



D3650-1 AFT PANEL



D3650-1B AFT PANEL BENT PART
(MAKE FROM D3650-1F FLAT PATTERN)



- NOTES:**
- 1) FINISH: NONE
 - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 5) IDENTIFICATION: NONE
 - 6) WEIGHT: 1.3 lbs

DEO ATTACHED

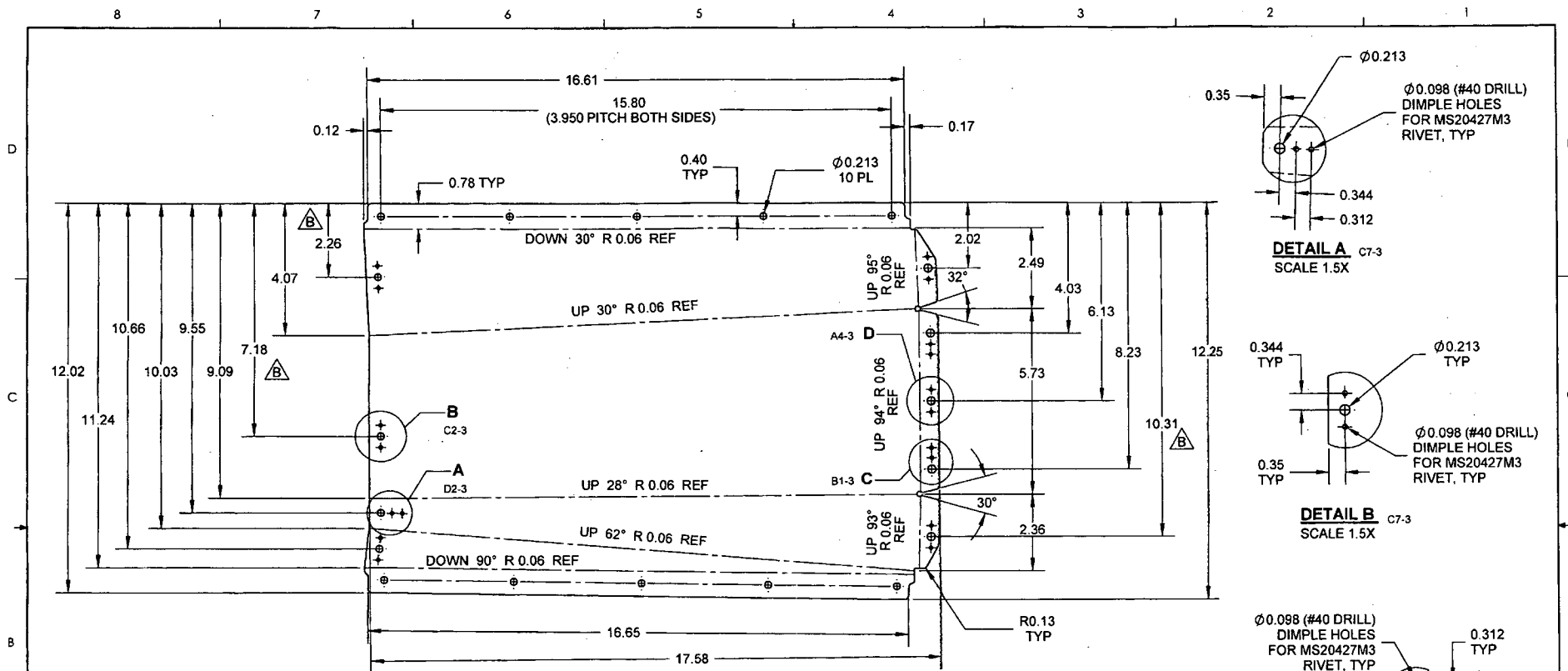
UNDER REVIEW
OK
P. 09.06.24

RELEASED
06/11/17

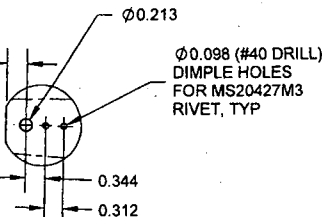
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66239

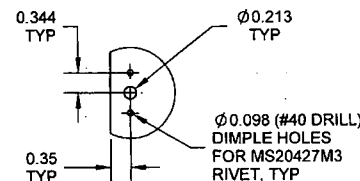
8 7 6 5 4 3 2 1



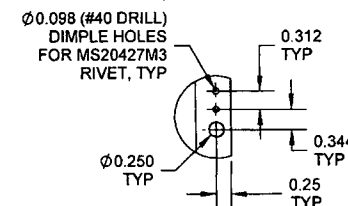
D3650-1F FLAT PATTERN



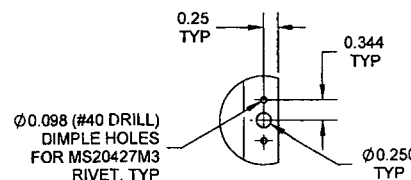
DETAIL A C7-3
SCALE 1.5X



DETAIL B C7-3
SCALE 1.5X



DETAIL C C4-3
SCALE 1.5X



DETAIL D C4-3
SCALE 1.5X

NOTES:



- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.22 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT⁴
WITHOUT NOTICE
WORK ORDER
NO. 66254

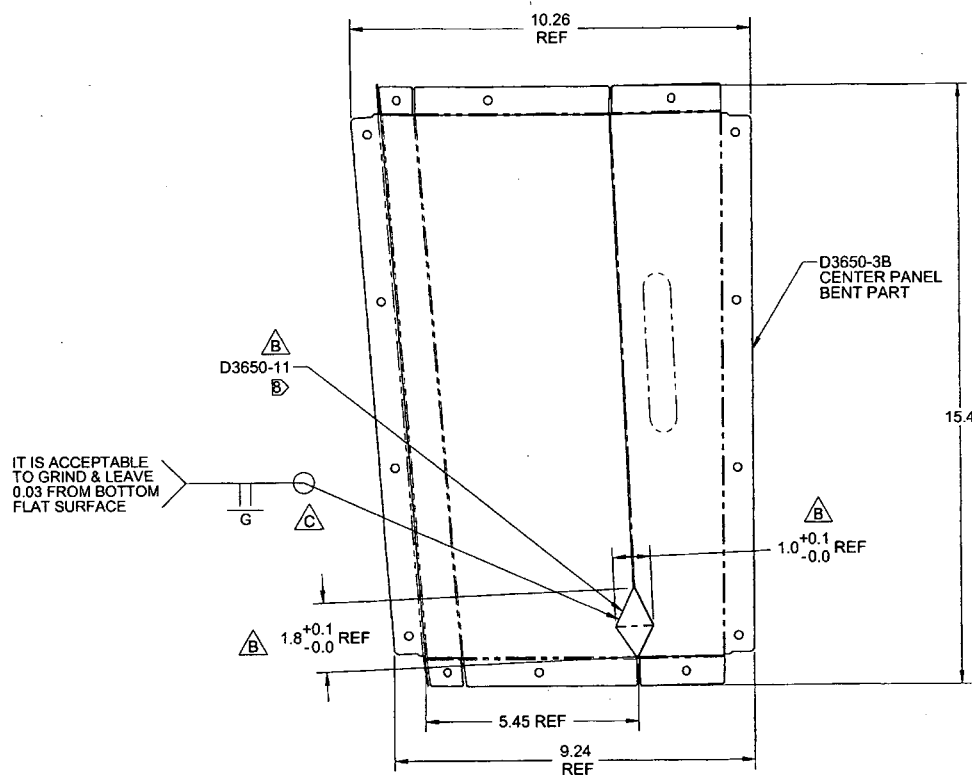
UNDER REVIEW

DEO ATTACHED

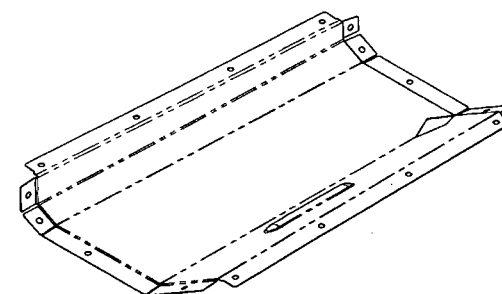
RELEASED
08/11/17

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 3 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

QTY	PART NUMBER	DESCRIPTION
-3		
X	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE



D3650-3 CENTER PANEL
(LOOKING FROM OUT SIDE SURFACE)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66254

DEO ATTACHED

RELEASED
08.11.17

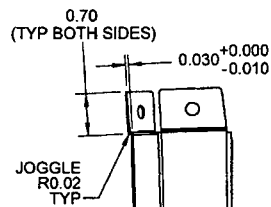
NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.0 lb
- 8) TRIM D3650-11 TO FIT AS REQUIRED

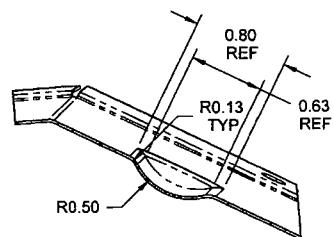
UNDER REVIEW

08.02.05
08.06.24

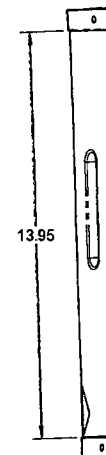
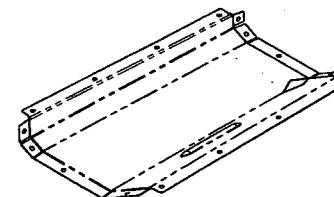
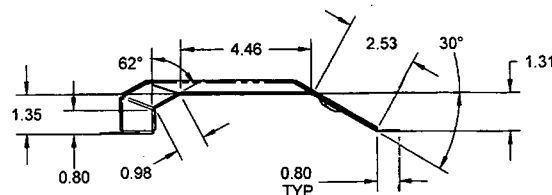
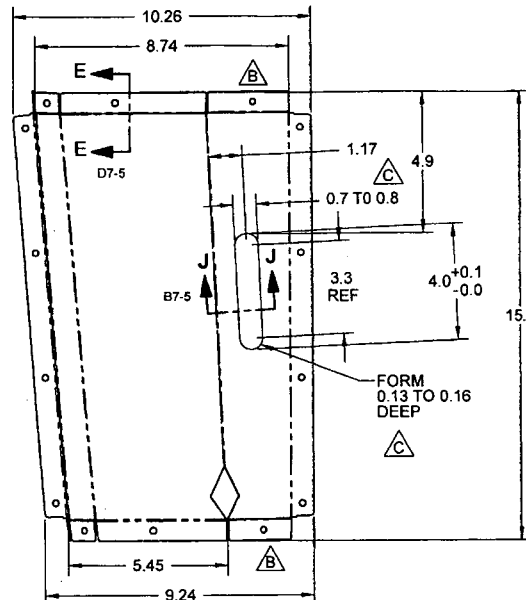
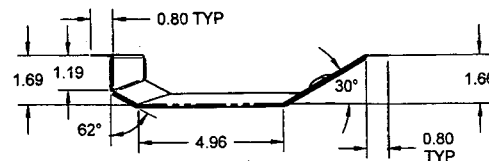
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3650	REV. C
MFG. APPR.	RF		SHEET 4 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION E-E D5-5
SCALE 2X



SECTION J-J C5-5
SCALE 3.5X



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66254





DEO ATTACHED

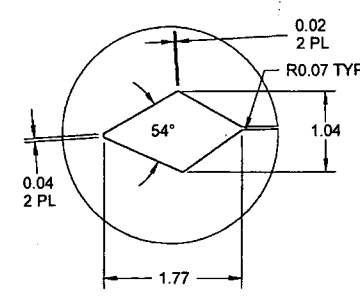
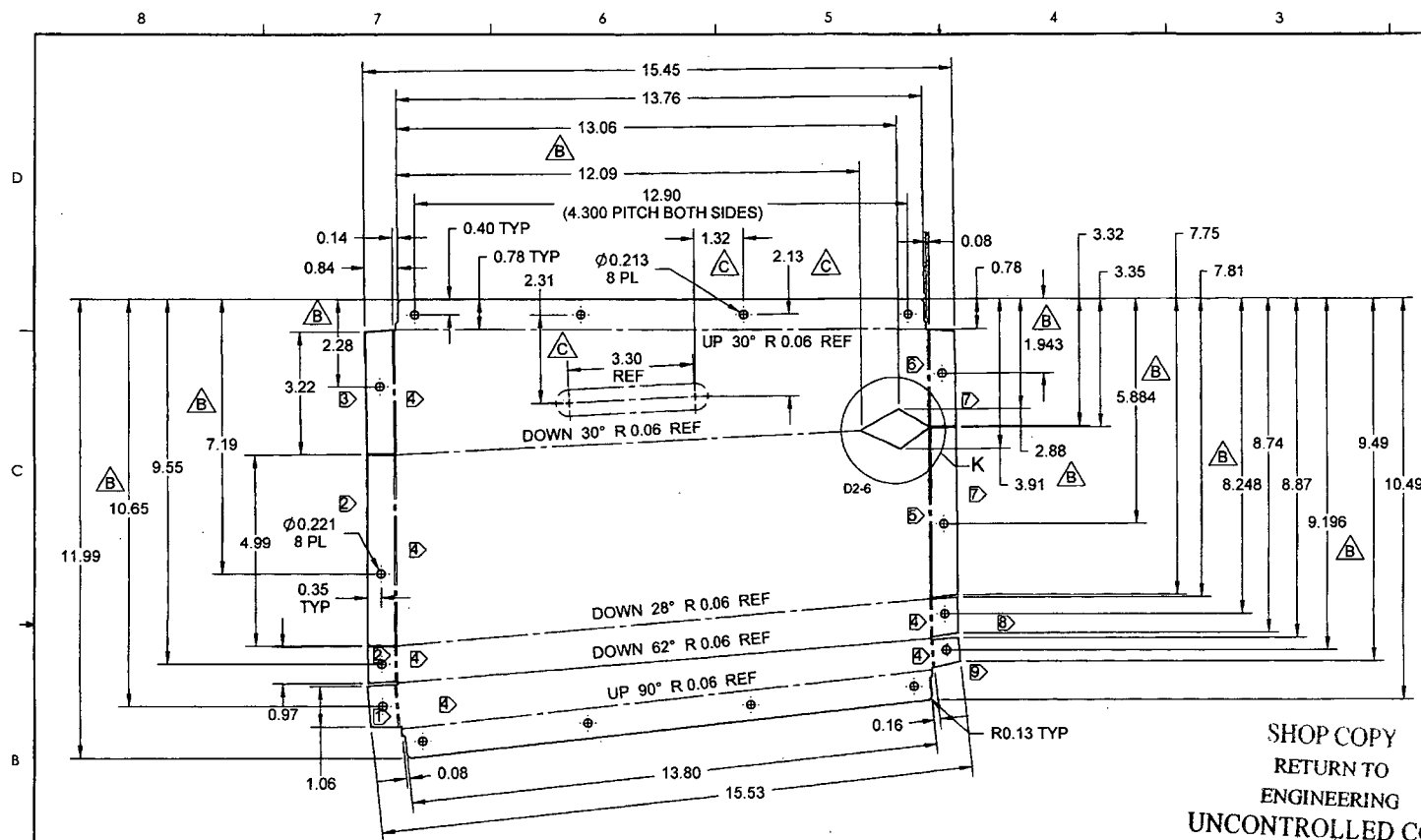
RELEASED
08/11/17 MJD

- NOTES:
1) FINISH: NONE
2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
3) UNITS: INCHES UNLESS OTHERWISE NOTED
4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
5) IDENTIFICATION: NONE

D3650-3B CENTER PANEL BENT PART
(MAKE FROM D3650-3F FLAT PATTERN)

UNDER REVIEW
19 07.02.02 OK 07.06.24

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 5 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



C5-6 **DETAIL K**
SCALE 2X

DEO ATTACHED

- ① DOWN 92° R 0.015
- ② DOWN 89° R 0.015
- ③ DOWN 86° R 0.015
- ④ UP 90° R 0.015
- ⑤ UP 88° R 0.015
- ⑥ UP 90° R 0.015
- ⑦ DOWN 88° R 0.015
- ⑧ DOWN 90° R 0.015
- ⑨ DOWN 94° R 0.015

D3650-3F CENTER PANEL FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66254

RELEASED
08/11/17

D3650-3F NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE

UNDER REVIEW
08.10.14
OK 08.10.14

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3650	SHEET 6 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

MS21062-3K NUTPLATE
MS20427M3-3 RIVET, 2 PL
2 PL

MS21060-3K NUTPLATE
MS20427M3-3 RIVET, 2 PL
2 PL

D3650-5B
FWD PANEL
BENT PART
REF

NAS1149CN432R
WASHER, REF

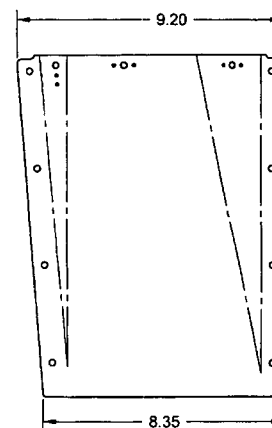
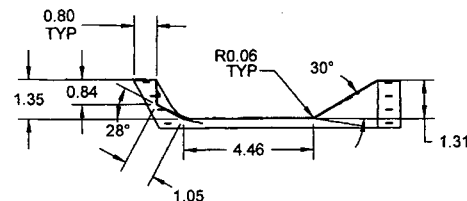
0.74
0.07

D3650-5B FWD PANEL
BENT PART
REF

MS20615-4M5
RIVET, REF

D3650-7-8.19 SEAL
D3650-9 ANGLE

DETAIL F
SCALE 3.5X



DEO ATTACHED

D3650-5B FWD PANEL BENT PART
(MAKE FROM D3650-5F FLAT PATTERN)

RELEASED
28/11/17 MB

PART LIST

QTY	PART NUMBER	DESCRIPTION
5	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

C

B

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs

D3650-5 FWD PANEL

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

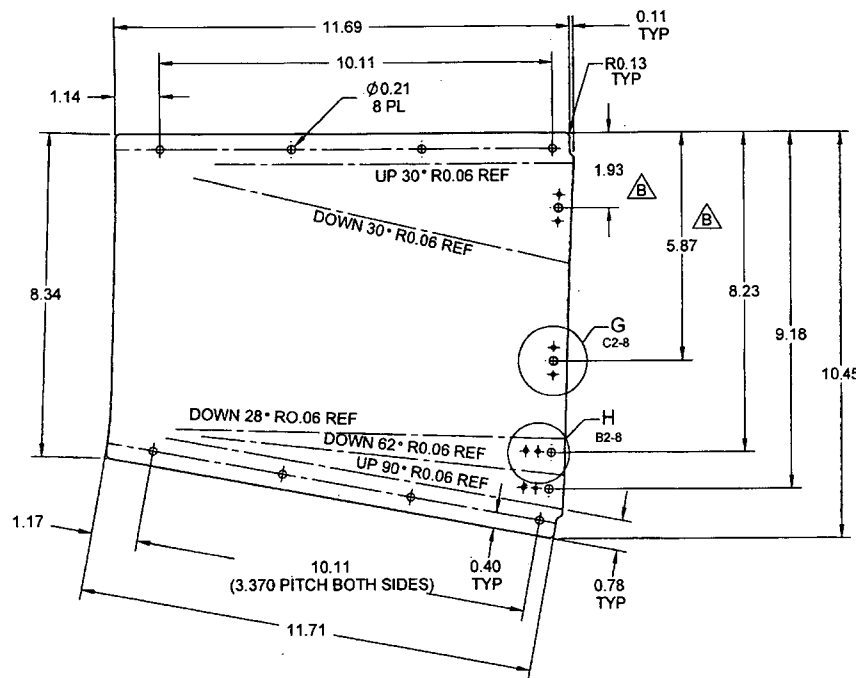
WITHOUT NOTICE
WORK ORDER

NO. 66254

UNDER REVIEW
17/11/17 MB

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	MB	DRAWING NO. D3650
MFG. APPR.	MB	REV. C
APPROVED	MB	SHEET 7 OF 9
DE APPR.	MB	TITLE TOP PANEL ASSEMBLY
DATE	08.10.14	SCALE NTS

COPYRIGHT © 2007 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD



D3650-5F FLAT PATTERN

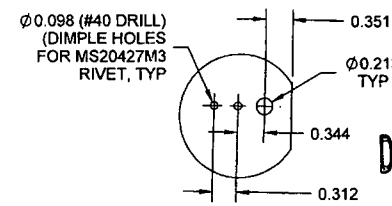
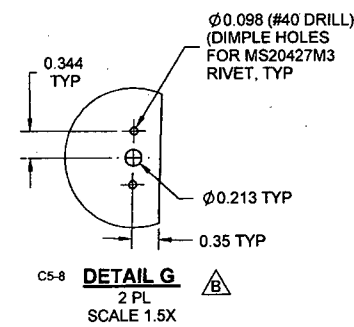
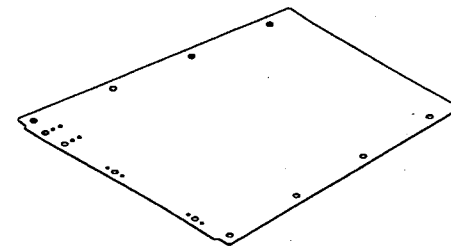
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 66254

UNDER REVIEW
[Signature]
OK 11/11/14

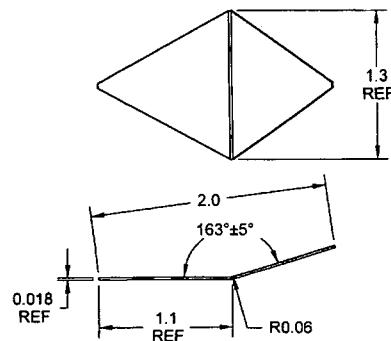


DEO ATTACHED

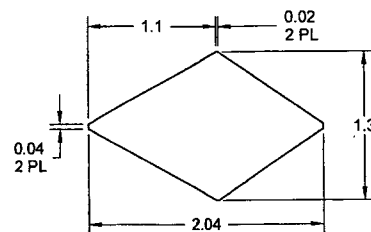
RELEASED
[Signature]

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3650	REV. C
MFG. APPR.	<i>[Signature]</i>	SHEET 8 OF 9	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TOP PANEL ASSEMBLY	
DATE	08.10.14	NTS	

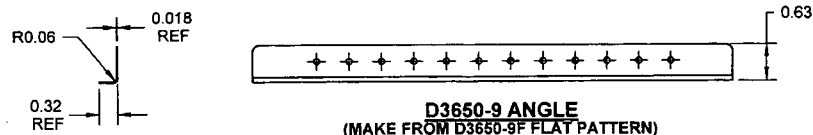
COPYRIGHT © 2007 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



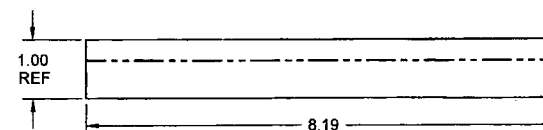
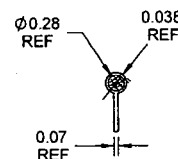
D3650-11 FILLER PLATE
(MAKE FROM D3650-11F FLAT PATTERN)



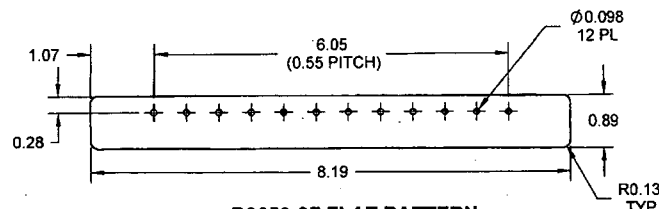
D3650-11F FLAT PATTERN



D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)



D3650-7-8.19 SEAL



D3650-9F FLAT PATTERN

D3650-7-8.19 NOTES:

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50




D3650-9 & D3650-11 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb
D3650-11 WEIGHT: 0.007 lb

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 66259

UNDER REVIEW
APPROVED
OK 4/11/02

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 9 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DEO ATTACHED

RELEASED
08/11/02

DRAWING NO. D3650	TITLE TOP PANEL ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3650-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN CP	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 09.06.12	DATE 04.06.15	DATE 09.06.15	DATE 09/06/15	DATE 09/06/15			

TO AMEND D3650-5 FWD PANEL:

REF PAR 09-008. THE QTY(12) NAS1149CN432R WASHERS ARE REPLACED WITH QTY(1) D3893-1 DOUBLER. THE QTY(12) MS20615-4M5 RIVETS ARE REPLACED WITH QTY(12) NAS9307M-4-03 RIVETS. LOCATION OF THE DOUBLER IS SHOWN IN THE AMENDED DETAIL F (DWG SHEET 7) BELOW. THE PARTS LIST FOR D3650-5 IS AMENDED AS FOLLOWS:

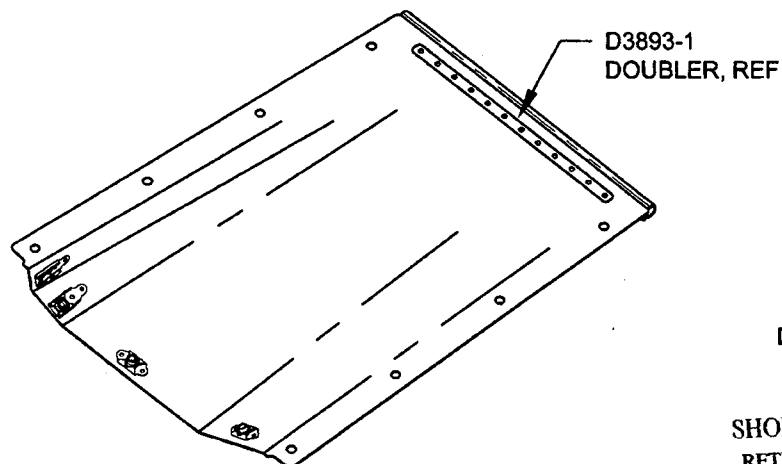
IS:

QTY	PART NUMBER	DESCRIPTION
-5		
1	D3893-1	DOUBLER
12	NAS9307M-4-03	RIVET (OR CR3523-4-03)

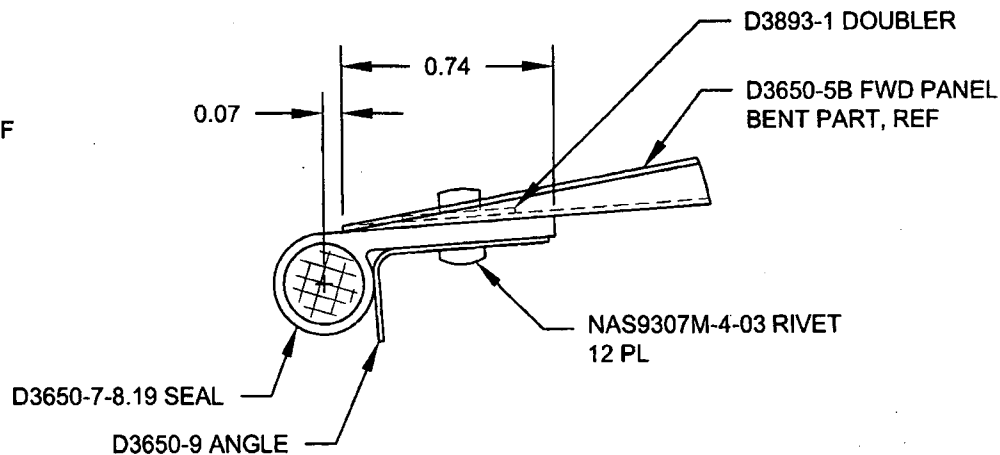
WAS:

QTY	PART NUMBER	DESCRIPTION
-5		
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET

RELEASED
09/06/15



D3650-5 FWD PANEL



DETAIL F C5-7
SCALE 3.5X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66254

COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.